

Technical Data Sheet

Ultra Flex® Seam Sealer & Adhesive is a solvent- and isocyanate-free multi-purpose sealant. It may be applied by caulking gun or spray equipment and is easily extruded and tooled. 4172 is a moisture curing sealant developed for automotive and industrial applications requiring elasticity, high strength and excellent adhesion. The product is tough, elastic and waterproof. It bonds aggressively to steel, aluminum, galvanized metal, fiberglass, urethane, epoxy, polyester, water-based primers, glass, Styrofoam® and many plastics.

SUITABLE SUBSTRATES

Substrate		Substrate		Substrate	
Bare Steel	✓	Raw Plastic - Rigid (SMC, BMC) +	✓	Primer - Self-Etching	✓
Bare Galvanized	✓	Raw Plastic - Flexible (ABD, PPO) +	✓	Primer - 1K	✓
Bare Aluminum	✓	Raw Plastic - Soft (PUR) +	✓	Primer - 2K	✓
OEM E-Coat**		Plastic Part - Primed ++	✓	OEM Finish & Old Paint Work - Reversible	✓
Fiberglass/SMC Gel Coat	✓	Body Filler	✓	OEM Finish & Old Paint Work - Non-Reversible	

** Aftermarket E-coat must be solvent tested with Transtar Urethane Grade Reducers 6700 or 6700-F Series in an inconspicuous spot before application of new coating.

+ Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

++ Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.

MIXING



By Volume: Ready to use

FLASH TIMES/DRY TIMES



Work time: 10 minutes
 Paint time: Immediately paintable
 Skin time: 12 minutes
 Full cure time: 12-24 hours (3/4" per 24 hours)

SURFACE PREPARATION



Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.
 * For more information on surface prep and application refer to next page.

LIMITATIONS & PRECAUTIONS

- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.
- See next page for more detailed production application.

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SURFACE PREPARATION

Cleaning: Surfaces must be clean and free from wax, silicone or grease. Clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

For Bonding: Abrading with 180-220 grit abrasive followed by cleaning with SCAT will improve the bond strength.

APPLICATION

Application: Apply bead of sealant along seam to be sealed. Sealant may be tooled as desired, and holds brush marks very well. Full cure will be achieved in 12 – 24 hours depending on humidity and material thickness.

NOTE: Product can be painted immediately. If product is to be painted, it must be painted within 2 hours to assure proper adhesion. If 4172 is not painted within 2 hours, simply apply one coat of TPO Adhesion Promoter 1021 at any time after 2 hours prior to applying subsequent coats.

TIP: Another strategy for handling extended paint times is to apply 2 in 1 Primer 4603/4613/4623/4633 immediately over the 4172 then abrading with a scuff pad (red or gray) and degreasing prior to painting.

TIP: To save unused material for later use, leave the plastic nozzle on the cartridge. This will keep moisture from entering the cartridge and curing the material. Simply replace the nozzle with a new one the next time you use the product.

Refer the Technical Datasheet for #4435 Sprayable Seam Sealer Gun for spraying application.

PRODUCT SPECIFICATIONS

Color: Tan	Shelf Life: 1 year
RTU Solids: 99%	Size: 11 fl oz (305 ml)

REGULATORY

Category: Adhesive			
VOC Actual	0	Weight % of Exempt Compounds	0
VOC Regulatory	0	Volume % of Exempt Compounds	0
Weight % of Volatiles	0.8	Density of Material #/gal	12.5
Weight % of Water	0		

PHYSICAL PERFORMANCE PROPERTIES

- Shore A Hardness 45
- Elongation 230%
- Tensile strength 190 psi
- Cold temp resistance @ -20°F (-28°C) remains flexible
- Heat temp resistance @ 200°F (93°F) no degradation